

Work Order ID 60618

Thursday, July 15, 2010 10:26:51 AM

Page 1

Item ID: D350-591-213

Accept

Revision ID:

Item Name: Heli-Access-Step, Short LH

Start Date: 7/15/2010 Start Qty: 2.00

Required Date: 7/22/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: *R*

Date: *10-7-15*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3078

A

DSI 9472

A

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D350-591-213 CHG003

0.00

8/10/06/05

Hg for BG 10/08/05

110

0.00



Large Fab

Large Fab

Large.Fab

Memo

1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078
2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets.
3-Deburr

0.00

10.07.25

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8/10/07/26

(72)

130



Large Fab

Large Fab

Large Fab

0.00

0.00

Memo

1-Bevel end for welding FWD ONLY
2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072
A/R Aluminum Rod *M112360*
3-Grind End Plate flush *M114242*

10.07.26

2

10

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

Memo

(2)

10

10.07.26

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control



10.07.26

10.07.27

2

2

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200



Large Fab

Large Fab

0.00

Memo

0.00

1- Rivet Leg Assembly as per Dwg D3078.
2-Bevel Aft end for welding
3-Inspect for foreign object as per QSI 024
4-Weld Aft End Plate as per QSI 004 & Dwg D3078
A/R Aluminum Rod M112860
5-Grind End Plate flush

Handwritten: 10-07-27

Handwritten: 2 0

210



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

Handwritten: 2 0 BE 10/08/03

220



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Handwritten: S 10/08/03

Handwritten: 12 44

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

2 BR 10-8-4

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:05
OVEN TEMPERATURE: 320°
FINISH TIME: 9:35

2 BR 10-8-4

250

Wing Walk as per dwg QSI005 4.4 Batch AA115028

0.00

HandFinish

Memo

0.00

Hand Finishing

=> M 10/08/04

X2W4 d

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Required Date: 7/22/2010 Req'd Qty: 2.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

260

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

P 10/15/10 (2)

270

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

P 10/15/10

280

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*Siolo 8/15**FO*
LM

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D350-591-213

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Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short LH

Start Date: 7/15/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

290

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D350-591-213

Location: 80
PPP Rev: E

10/6/5 sf (20)

300

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/08/05 JF
MF 10-8-05

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 60618

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH




Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC
 IPP Rev:C 06-06-19 Added D2732-030 AS PER DS19294 JLM
 IPP Rev:C 06-06-27 Revised as per DS19340 JLM IPP Rev:D
 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C  Step Extrusion		Manufactured	No			110	Each	120.9200	0.5	1			
<div> <div>Location</div> <div>WA</div> <div>55214</div> <div>58544</div> </div> <div> <div>Loc Qty</div> <div>120.92</div> <div>3.92</div> <div>117</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3067-1  End Plate		Manufactured	No			130	Each	43.0000	1	2			
<div> <div>Location</div> <div>WA</div> <div>B60141</div> <div>57926</div> <div>59596</div> </div> <div> <div>Loc Qty</div> <div>43</div> <div>3</div> <div>40</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3063-1  Support		Manufactured	No			130	Each	42.0000	1	2			
<div> <div>Location</div> <div>WA</div> <div>51237</div> <div>59663</div> </div> <div> <div>Loc Qty</div> <div>42</div> <div>2</div> <div>40</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

10.07.25

10.07.26

10.07.26

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

Work Order ID: 60618

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS20600-AD4W4

Purchased

No

180

Each

799.0000

16

32



Rivets

Location

Loc Qty

Loc Code

ST321

799

113368

62

114181

11

114718

2

114935

724

D3066-1

Manufactured

No

180

Each

163.0000

2

4



Spacer

Location

Loc Qty

Loc Code

WA

163

58540

77

60194

86

D3065-041

Manufactured

No

180

Each

44.0000

1

2



Step Leg Assembly Hi

Location

Loc Qty

Loc Code

WA

44

58536

4

59678

40

D3067-1

Manufactured

No

200

Each

43.0000

1

2



End Plate

Location

Loc Qty

Loc Code

WA

43

57926

3

59596

40

Thursday, July 15, 2010 10:26:55 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
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Parent Item Name: Heli-Access-Step, Short LH

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

AN3-35A Purchased No 270 Each 197.0000



Bolt

Location	Loc Qty	Loc Code
ST353	197	
115016	97	
115108	100	

D2856-400 Manufactured No 270 f 160.9388 0.6



Abraison Strip

Location	Loc Qty	Loc Code
ST403	160.9388421	
56626	160.938842	

cut qty of 1 at 4.00" X 7.20" as per dwg (D2856-400-720)

AN4-11A Purchased No 270 Each 273.0000



Bolt

Location	Loc Qty	Loc Code
ST357	273	
110382	273	

AN960JD4T6 NAS1149D0463J Purchased No 270 Each 0.0000



Washer

D2230-1 Manufactured No 270 Each 5.0000



Lug

Location	Loc Qty	Loc Code
ST476	5	
59909	5	

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Shop Packet Print

Page 3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DCA: _____ Date: _____

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Page 4

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Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

270

Each

2,684.000

2

4



Nut



Handwritten signature

Location

Loc Qty

Loc Code

ST300

2684

112385

4

114523

204

114718

476

114784

2000

114718

AN4-13A

Purchased

No

270

Each

806.0000

4

8



Bolt



Handwritten signature

Location

Loc Qty

Loc Code

ST351

4

109282

4

ST357

302

114941

252

115108

50

ST358

500

115159

500

115108

D2732

Manufactured

No

270

f

342.2070

1

2.105263



Rubber Extrusion



Handwritten signature

Location

Loc Qty

Loc Code

ST412

342.207

56516

342.207

56516

cut qty of 4 at 3.00" as per dwg(D2732-030)

Measure 5/10/05/05

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Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 2.00

Required Qty: 2.00

D2230-3 Manufactured No 270 Each 115.0000



Lug

Location

Loc Qty

Loc Code

ST476	115
55452	2
59115	1
59418	112

0.0000

AN960JBT0 NAS1149D0363J Purchased No 270 Each



Washer

MS21042L4

Purchased No 270 Each



Nut

Location

Loc Qty

Loc Code

ST300	4191
113422	68
114523	28
114718	95
114784	2000
115108	2000

155.0000

AN4-16A Purchased No 270 Each



Bolt

Location

Loc Qty

Loc Code

ST358	155
114523	55
115016	50
115159	50

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3078	REV. A SHEET 1 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, HI SHORT SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED
02.09.20 *#*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *60618*
PS 10-7-15

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

GENERAL NOTES:

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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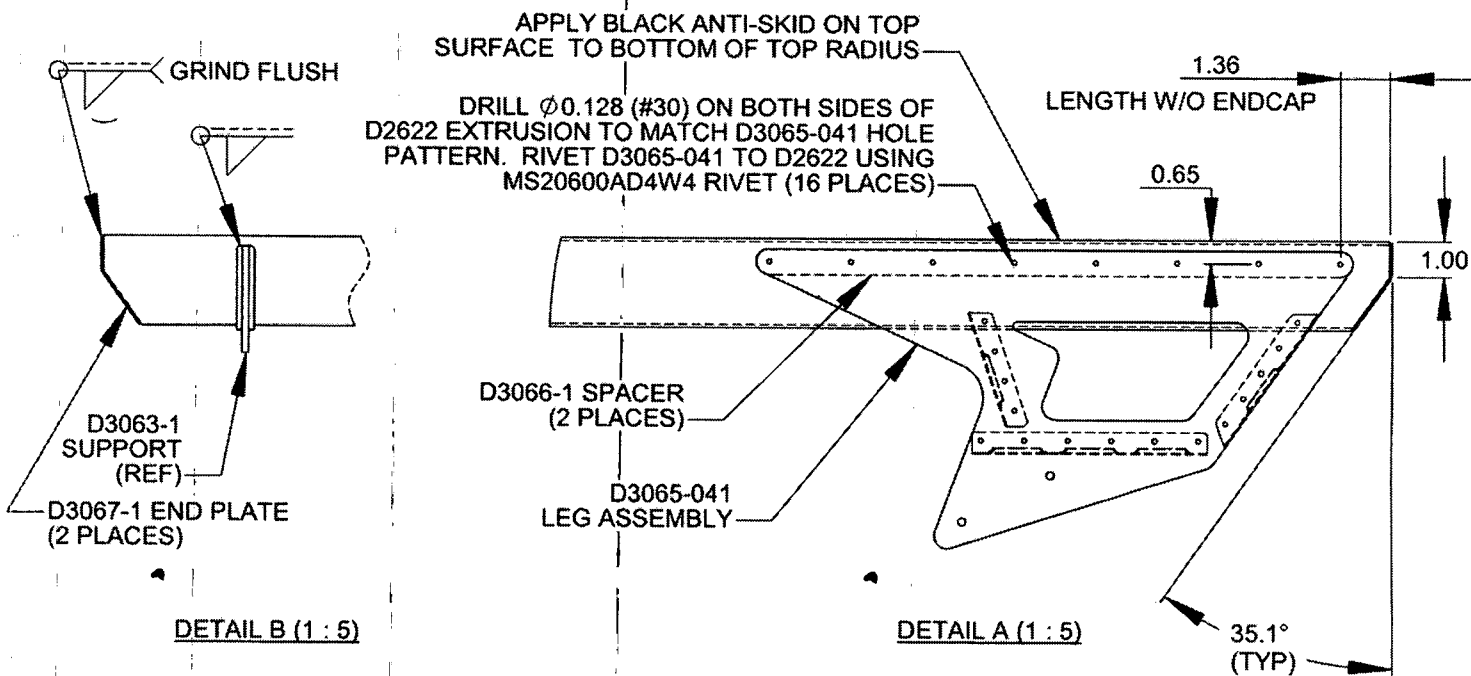
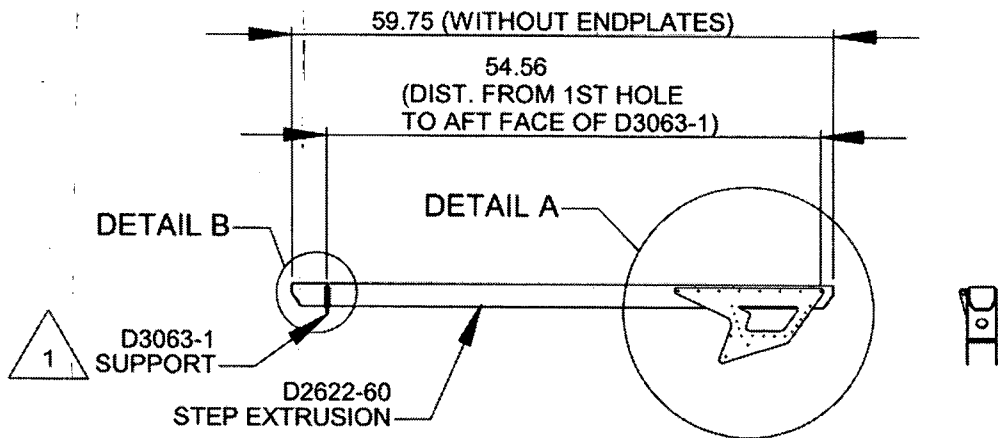
NOTE: Date & initial all entries

DART



DESIGN	W	DRAWN BY	W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	W	APPROVED	W	REV. A
DATE	02.09.11	DRAWING NO.	D3078	SHEET 2 OF 2
TITLE	STEP ASSEMBLY, HI SHORT	SCALE	1:20	

RELEASED
02.09.2004



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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying crosstube diameters and to improve fit, as indicted in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:



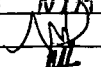
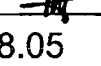
ADD:

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 09.08.05
CERT. NO.: SH92-6
ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
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